



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2616-1

Job Sheet 178776



Part No: D2616-1

Job Qty: 20 ea

Part Name: Mounting Lug, EC120 Step



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/7/18

Job Tracking No:

Due Date: 9/24/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP Rev:C 00.06.22 Removed P/O for powder coat EC IPP Rev:D 07-12-17 rev E as per dwg ECN 1069 DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	9/24/18	9/24/18	0.00	0.00	Start Up Machining-1		
100	Bandsaw	20 pcs	9/24/18	9/24/18	0.00	0.01	Bandsaw1		
110	CNC Vertical Machining	20 pcs	9/24/18	9/24/18	0.00	11.43	HAA81-2 HAAS Saxis		
130	QC	20 pcs	9/24/18	9/24/18	0.00	0.00	QC8 Machining-1		
140	HandFinish	20 pcs	9/24/18	9/24/18	0.00	0.70	HandFinish1		
150	Powdercoat	20 pcs	9/24/18	9/24/18	0.00	0.29	Powdercoat3		
160	QC	20 pcs	9/24/18	9/24/18	0.00	0.00	QC3		
170	Small Fab	20 pcs	9/24/18	9/24/18	0.00	1.54	Small Fab-2		
180	QC	20 pcs	9/24/18	9/24/18	0.00	0.00	QC5		
190	Packaging	20 pcs	9/24/18	9/24/18	0.00	0.00	Packaging3-1		
200	QC21-SA	20 Ea	9/24/18	9/24/18	0.00	0.00	QC21		

Part Op 100 - Cut blanks at 2.25"

Descriptions: 110 - 1-Machine as per folio FB477 & DWG D2616. 2- Deburr.

130 - QC8- Inspect parts - second check

140 - Chemical Conversion Coat per QSI005 4.1

150 - Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Note:Mask large hole START TIME: 11:35 OVEN

TEMPERATURE: 320° FINISH TIME: 12:05 M136370.

160 - QC3- Inspect Part Finish

170 - 1-Coat bearing in light oil 2-Press Bearing in D2616-1 3-Stake as per Dwg D2616 using DT8019 4- Touch up paint if required

180 - QC5- Inspect part completeness to step on W/O

190 - Identify as per dwg & Stock Location:

200 - QC21- Final Inspection - Work Order Release

OCT 09 2018

21
9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2611	Bearing	20 Ea (1 ea)	90-Start up Operation	5107627
M6061T6B2.500X01.250	6061-T6 Bar 2.50 X 1.25	3.7500 ft (.1875 ea)	90-Start up Operation	5116 528
		3.864'		

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2611	20	14	0
	M6061T6B2.500X01.250	4	0	0

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																		
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Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fwd Mounting Lug	17.000Degrees ± 0.500	17.500 16.500		
2	Fwd Mounting Lug	2.000inches ± 0.010	2.010 1.990		
3	Fwd Mounting Lug	0.622inches ± 0.010	0.632 0.612		
4	Fwd Mounting Lug	0.511inches ± 0.010	0.521 0.501		
5	Fwd Mounting Lug	0.313inches ± 0.010	0.323 0.303		
6	Fwd Mounting Lug	1.000inches ± 0.010	1.010 0.990		
7	Fwd Mounting Lug	1.125inches ± 0.010	1.135 1.115		
8	Fwd Mounting Lug	0.250inches ± 0.010	0.260 0.240		
9	Fwd Mounting Lug	1.250inches ± 0.010	1.260 1.240		
10	Fwd Mounting Lug	0.375inches ± 0.010	0.385 0.365		
11	Fwd Mounting Lug	0.625inches ± 0.010	0.635 0.615		
12	Fwd Mounting Lug	1.259inches ± 0.010	1.269 1.249		
13	Fwd Mounting Lug	0.625inches ± 0.010	0.635 0.615		
14	Fwd Mounting Lug	0.250inches ± 0.010	0.260 0.240		
15	Fwd Mounting Lug	0.063inches ± 0.010	0.073 0.053		
16	Fwd Mounting Lug	0.257inches + 0.006 - 0.001	0.263 0.256		
17	Fwd Mounting Lug	0.8120inches + 0.0000 - 0.0005	0.8120 0.8115		

Plex 6/7/18 12:33 PM dart.lajeunesse.marie



Container No: S116547



Part: D2616-1

Job No: 178776

Serial No/Batch: S116547

Revision: E

Inspector:

Exp Date:

Instructions: Various STC's

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/09/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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